

Work Order ID 83616

83616

Page 1

April-20-12 1:25:57 PM

Item ID: D412-742-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Float Skidtube Installation

Stop ***NS2***

Start Date: 20/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/04/20

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN D412-742	E
--------------	---

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013 CHG007

JB

①

12/05/10

For MLS 12-5-9

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

1

12/05/09 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

①

12/05/10

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83616***83616***

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April-20-12 1:25:57 PM

Item ID: D412-742-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Float Skidtube Installation

Stop ***NS2***

Start Date: 20/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location: _____								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

12/15/14 (1)

12/15/14

mf
12-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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83616

D412-742-013

Required Date: 04/05/2012

Required Qty: 1.00

IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DS19336 JLM IPP Rev: C
 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DS19441 DD verified by: EC IPP Rev: F add
 AN4C7A DD 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per
 DS19517 REV. B DD verified by: EC IPP rev: H 12.01.12 PER IIN
 REV. E DD VERF: IPP Rev: I add AN4C47A DD 12.03.14
 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A		Purchased	No			110	Each	34.0000	4	4			
AN4C47A Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST361				34					
				118451				6					
				119798				2					
				121009				26					
D412-742-043		Manufactured	No			110	Each	0.0000	1	1			
D412-742-043 Replacement Float Skidtube													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2571

Manufactured No

110

Each

18.0000

1

1

D2571

Saddle, Fwd Out 205

**

✓ JB

Location

Loc Qty

Loc Code

ST

1

11644

1

ST425

-13

ST432

17

80828

1

81764

10

82049

6

ST433

13

81764

D2572

Manufactured No

110

Each

14.0000

1

1

D2572

Saddle, Fwd In 205

**

✓ JB

Location

Loc Qty

Loc Code

ST432

14

71107

2

81765

6

82050

6

82050

D2573

Manufactured No

110

Each

16.0000

1

1

D2573

Saddle, Aft Out 205

**

✓ JB 12/05/09

Location

Loc Qty

Loc Code

ST423

-12

79424

0

ST433

16

81221

6

82048

10

ST434

12

82048

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2574

Manufactured No

110

Each

16.0000

1

1

✓

D2574

Saddle, Aft In 205

**

JB

Location

Loc Qty

Loc Code

ST433

16

81220

4

82368

12

82368

S u r

D2876

Manufactured No

110

Each

57.0000

2

2

✓

D2876

Saddle Spacer

**

JB

Location

Loc Qty

Loc Code

ST020

57

79693

57

79693

S u r

D2877

Manufactured No

110

Each

7.0000

2

2

✓

D2877

Saddle Spacer

**

82026

JB

S u r

Location

Loc Qty

Loc Code

ST020

7

78843

7

D3403-1

Manufactured No

110

Each

151.0000

8

8

✓

D3403-1

Bushing

**

JB

12/05/09

Location

Loc Qty

Loc Code

ST041

15

70696

15

ST042

136

80208

7

80219

28

81529

101

81529

S u r

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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3403-5
D3403-5
Bushing

Manufactured No

110 Each

134.0000 8 8

**

JB

Location

Loc Qty

Loc Code

ST042

134

80221

23

81531

111

81531 525

D2747
D2747
Set Screw

Manufactured No

110 Each

268.0000 4 4

**

JB

Location

Loc Qty

Loc Code

ST017

268

79520

68

81877

200

79520 525

D3533-1
D3533-1
Set Screw

Manufactured No

110 Each

54.0000 2 2

**

JB

Location

Loc Qty

Loc Code

ST053

54

80326

54

80326 525

AN4C6A
AN4C6A
Bolt

Purchased No

110 Each

223.0000 16 16

**

15x121656 525 12/03/09

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

219

116704

2

120423

200

120521

17

1x120423 525

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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C53A
AN4C53A
Bolt

Purchased No

110 Each 70.0000 4 4 ✓
**

Location

Loc Qty

Loc Code

ST361
121183
121184

70
68
2

121183 S.C.R.

AN4C52A
AN4C52A
BOLT

Purchased No

110 Each 104.0000 4 4 ✓
**

Location

Loc Qty

Loc Code

ST361
117688
120364
120465

104
6
76
22

120364 S.C.R.

AN6C12A
AN6C12A
BOLT

Purchased No

110 Each 86.0000 8 8 ✓
**

Location

Loc Qty

Loc Code

ST341
121302

86
86

121302 S.C.R.

D3672-3
D3672-3
Phenolic Washer

Manufactured No

110 Each 654.0000 32 32 ✓
**

Location

Loc Qty

Loc Code

ST060
64176
81870
83238

654
153
1
500

83238 S.C.R.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C416L NAS1149C0432R Purchased No

110 Each 0.0000 32 32

*AN960C416I *

**

WASHER

D3672-9 Manufactured No

110 Each 444.0000 8 8

D3672-9

**

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

444

81763

444

NAS1149C0632R Purchased No

110 Each 119.0000 8 8

NAS1149C0632R

**

WASHER

Location

Loc Qty

Loc Code

ST297

119

119736

2

120308

17

121060

100

D3672-11 Manufactured No

110 Each 339.0000 8 8

D3672-11

**

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

339

77483

339

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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,524.000

29

29

**

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1484

119546

213

120308

271

121162

1000

D3403-3

Manufactured

No

110

Each

87.0000

8

8

**

D3403-3

Bushing

Location

Loc Qty

Loc Code

ST042

87

81530

87

D3405-041

Manufactured

No

110

Each

30.0000

1

1

**

D3405-041

Lug Assembly

Location

Loc Qty

Loc Code

ST478

30

62227

2

77000

2

82031

10

82032

16

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Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

26.0000

1

1

**

D3405-043

Lug Assembly

Location

Loc Qty

Loc Code

ST

15

58328

0

82037

15

ST478

11

82038

11

82037

5 18

AN4C7A

Purchased

No

110

Each

191.0000

4

4

**

AN4C7A

Bolt

Location

Loc Qty

Loc Code

ST356

191

109147

191

109147

5 18

D3407-041

Manufactured

No

110

Each

53.0000

1

1

**

D3407-041

Tow Ring

Location

Loc Qty

Loc Code

ST463

53

82067

9

82068

33

82108

11

82068

5 18

D3417-3

Manufactured

No

110

Each

55.0000

2

2

**

D3417-3

Washer

Location

Loc Qty

Loc Code

FG

9

33519

9

ST042

46

80225

46

80225

5 18

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Page 8

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1 Manufactured No

110 Each

106.0000 1 1 ✓

D3456-1

Washer

**

JB

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

99

80252

3

81876

96

81876 ser

AN3C37A

Purchased No

110 Each

186.0000 1 1 ✓

AN3C37A

BOLT

**

121584 JB. ser

Location

Loc Qty

Loc Code

ST354

186

116874

11

117010

2

120422

23

120731

50

121068

100

AN3C40A

Purchased No

110 Each

39.0000 1 1 ✓

AN3C40A

BOLT

**

JB 12/05/09

Location

Loc Qty

Loc Code

ST354

39

114442

39

114442 ser

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

219.0000

1

1

AN3C41A

BOLT

**

121689 JB

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

215

119673

50

120753

30

121013

50

121067

5

121313

80

AN3C42A

Purchased

No

110

Each

56.0000

1

1

AN3C42A

BOLT

**

JB

Location

Loc Qty

Loc Code

ST354

56

106176

1

119673

5

120464

25

121103

25

120464

AN3C43A

Purchased

No

110

Each

137.0000

4

4

AN3C43A

BOLT

**

JB

12/05/09

Location

Loc Qty

Loc Code

ST354

137

114455

2

119673

1

120364

34

120465

100

120364

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83616

83616

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Purchased No

110 Each

100.0000

5

5

AN3C46A

BOLT

**

3x121585 JB on

Location

Loc Qty

Loc Code

ST355

100

103

40

120447

60

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

26

26

*AN960C10I *

washer

MS21043-3

Purchased

No

110

Each

1,301.000

13

13

MS21043-3

Nut

**

121509 JB S u

**

JB 12/05/09

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

140

120693

140

ST301

1089

118077

2

118614

83

118686

30

119758

20

121255

954

121255 S u

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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